

5/42

DART AEROSPACE LTD	Work Order:	24336
Description: Seal	Part Number:	D3117-1
Rev. 04.11.29		
Dwg: D3117 Rev. A B C	Qty:	500
Rev. 05.6.04		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	AK	05.09.26	500
2	PG	Issue P/O: <u>2008132</u> D3117-1 Seal as per Dwg D3117 Possible Supplier: VIP Rubber Replace Premier P/N: B45-43000-01 Material release note required	AK	05/10/04	500
3	RG	Receive and inspect for transit damage Ensure material release note is attached	CL	05/12/13	518
4	QC6	Inspect dimensions as per Dwg D3117 and certification attached.	2	05-12-13	518
5	PG	Issue P/O: Cut Qty 3 sample 12" long of D3117-1 Send for testing to meet vertical burn test per F.A.R. 25.853 Possible testing site: Bodycote Materials Testing Canada Inc. Test report is required	Not applicable see attached E-mail		
6	RG	Attach test report to W/O			
7	ST	Identify and Stock Loc 337 + 346	CL	05/12/14	518 FT
8	AC	Cost / part	545	05-12-15	518
9	DC	Close W/O Inspect Level 21	LD	05/12/15	518

Rev	Date	Change	Revised By	Approved
A	03.01.22	New issue	KJ/RF RF	

RELEASED
03.01.23 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

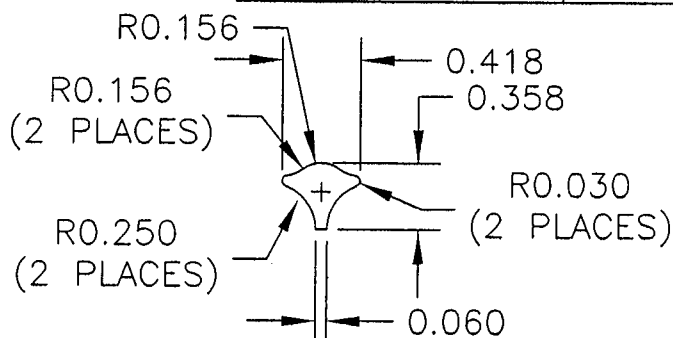
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



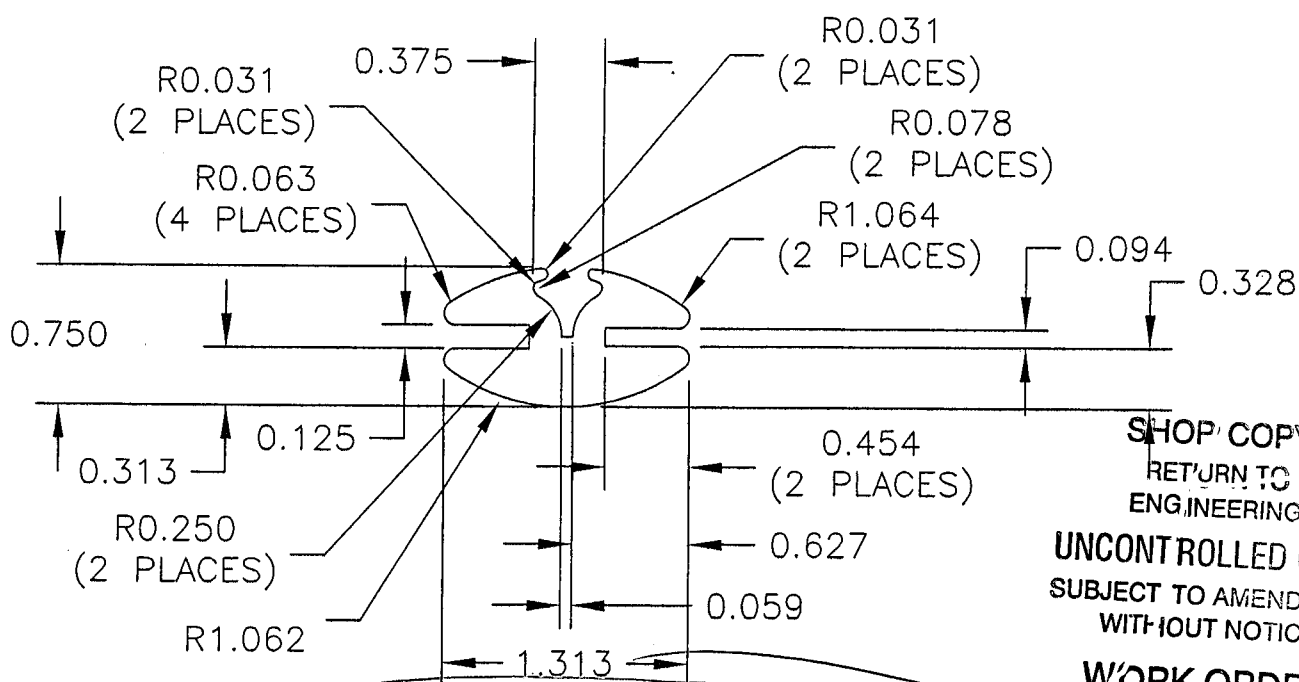
DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3117	REV. C SHEET 1 OF 1
DATE 05.10.03		TITLE SEAL	SCALE 1:1
A	02.04.15	NEW ISSUE	
B	04.10.18	UPDATES NOTES	
C	05.10.03	50 DUROMETER WAS 60 DUROMETER	



RELEASED
05.10.03 *[Signature]*

D3117-3-XXXX SEAL FILLER

REPLACES PREMIER P/N B45-43000-03



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 24336

D3117-1-XXXX SEAL RETAINER

REPLACES PREMIER P/N B45-43000-01

NOTES

- 1) -XXXX = LENGTH IN INCHES (EG. 10" LONG = -0100, 87.5" LONG = -0875)
- 2) MATERIAL: BLACK RUBBER 50 DUROMETER (HARDNESS) NEOPRENE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 26, 2005
10:48 am

Work Order No : 0024336
Project Name : D3117-1
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D3117-1
Description : Seal Retainer
Manufactured : Yes
Amount Req'd : 500
Amount Done : 0
Start Date : 09-26-05
Est Finish Date : 10-12-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Blue
order

EXTRUDED AND MOLDED RUBBER • EXTRUDED PL
540 S. CYPRESS STREET, LA HABRA, CA 90631
(310) 905-3456 • (800) 722-4VIP
Fax: (310) 905-3460

**CERTIFICATION
OF COMPLIANCE**

ITEM NO
RE-7107-1897-0156

CUSTOMER PO
2008732

SHIPPER NO.

48151

DATE
10-17-05

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY ONTARIO, CANADA
K6A1K7 613-632-9577

#5263

PART NO./DESCRIPTION

P/N D3117-1 REV C RETAINER
P/N D3117-3 REV C FILLER

**QUANTITY
ORDERED**

500 FT
500 FT

(DWG. #D3117 REV C)

CURE DATE

4005

SPECIFICATION
50/NEOPRENE FORMULATED TO MEET THE FLAME
RESISTANCE TEST OF FAR 25.853a

By

Edward V. ...

President

VIP RUBBER COMPANY

J

DATE SHIPPED

12/1/05

QTY SHIPPED

513'
513'

Linda Lacelle

From: David Shepherd [davids@dartaero.com]
Sent: Wednesday, December 14, 2005 11:45 AM
To: Linda Lacelle
Cc: Jean-Luc Menard
Subject: Re: D3117

For some reason, Premier had put a note on their drawing to test every batch of this stuff. So when we created our drawing, we did the same. However, we now have our own STC for this product and at Rev. C, the note about testing every batch has been removed. Therefore, you DON'T need to send to Bodycote for burn testing. JL should remove this requirement if it is still on the IPP.

David

----- Original Message -----

From: "Linda Lacelle" <llacelle@dartaero.com>
To: "*David Shepherd (E-mail)" <davids@dartaero.com>; "*Roberto Fuentes (E-mail)" <robertof@dartaero.com>
Sent: Wednesday, December 14, 2005 5:26 AM
Subject: D3117

>
> Hi,
> The w/o's for D3117-1 / -3 are asking to issue a P.O to Bodycote fo a burn
> test ??? Isn't this done just once? Should this still be on the IPP ?
> LL
>
>